

Work Order ID 70715

Monday, June 27, 2011 11:16:38 AM



Page 1

Item ID: D206-642-514

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 6/13/2011 Start Qty: 1.00

Required Date: 6/14/2011 Req'd Qty: 1.00

Cust Item ID:

Customer: CU-DAR001

Reference: RMA RA111217 - RETURN-REWORK

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev L

100

QC - Inspect dimensions to dimension sheet

0.00



QLS

QC

Memo

0.00

Quality Control

INSPECT RA111217

8/16/13

110

0.00



HandFinish

Memo

0.00

Hand Finishing

-REMOVE AFT CAP AND CLEAN OUT ALL LPS FROM INSIDE &
OUTSIDE OF TUBE
-RE-INSTALL AFT CAP AS PER QSI005
-REMOVE WEARPLATES. REMOVE AND DESTROY/SCRAP ORIGINAL
GASKETS
REPLACE WITH NEW ONES
1 X D3536-15 B *66559*
1 X D3536-23 B *66560*
1 X D3536-35 B *69755*
1 X D3536-39 B *66241*
RE-INSTALL ORIGINAL WEARPLATES

DART				TEL: 1-613-632-3336 FAX: 1-613-632-4448	
TRANSPORT CANADA APPROVAL # 09-89					
PN	D206-642-514	CHG	CHG002		
DESC	Float Skidtube RH	SIC	SH98-4		
LOT	B42293	SIC	SA00475SE		
MODEL	Bell 206L/L1/L3/L4/407	SIC			
US PATENT 2,573,548				MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING					

1 6 11/07/03

- 02938-2 # 41131 x 1 remove

Work Order ID 70715

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Item ID: D206-642-514

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111217

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

0.00



Packaging

Memo

0.00

Packaging

REMOVE FROM KITS:
16 X D3672-5 B35521 (RETURN TO STK) ✓
25 X AN3C36A B109771 (RETURN TO STK)

ADD TO KITS:

16 X D3672-7 B
35 X AN3C37A B

1x D2938-2 #69920

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/12/11

6/17/11

6/17/11

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Item ID: D206-642-514

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111217

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

D



Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP USING NEW B/N
NEW PAPERWORK AND LABELS REQ'D

CHG003

HARCL 11-7-12

11/7/15

160

0.00

QC21- Final Inspection - Work Order Release



QC

Memo

0.00

Quality Control

11/7/18

ME

11-07-15

Picklist Print

Monday, June 27, 2011 11:16:35 AM

Page 1

Work Order ID: 70715

Parent Item: D206-642-514

Parent Item Name: Skidtube RH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-10-06 JLM
IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
IPP rev D 07.06.06 added K642-514 EC
IPP Rev:E 07-12-05 ECN 1080p Rev:L DD verified by:
IPP Rev:F 08-12-09 chg as per DSI9427 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C36A BOLT		Purchased	No				Each	133.0000		-25			

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
FP-B	31	
111925	31	
ST303	8	
116590	8	
ST353	80	
117125	30	
117872	50	

AN3C37A BOLT	Purchased	No	Each	107.0000	34	
---------------------	-----------	----	------	----------	----	--

Location	Loc Qty	Loc Code
ST353	98	
116874	11	
117010	2	
117763	25	
117885	60	
ST354	9	
117343	9	

M1099-71

6/17/13

M117885

Picklist Print

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Page 2

Work Order ID: 70715

Parent Item: D206-642-514

Parent Item Name: Skidtube RH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D206-642-514 Manufactured No

Each 0.0000

1



42293

Skidtube RH

D3536-15 Manufactured No

Each 17.0000

1



1107103

Gasket

Location

Loc Qty

Loc Code

FP011

17

66559

17

xs

D3536-23 Manufactured No

Each 36.0000

1



1107103

Gasket

Location

Loc Qty

Loc Code

FP011

36

43406

1

66560

9

69902

26

xs

D3536-35 Manufactured No

Each 24.0000

1



1107103

Gasket

Location

Loc Qty

Loc Code

FP012

24

69755

24

xl

D3536-39 Manufactured No

Each 35.0000

1



1107103

Gasket

Location

Loc Qty

Loc Code

FP015

35

~~66241~~

9

69760

26

xl

Monday, June 27, 2011 11:16:36 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 70715

Parent Item: D206-642-514

Parent Item Name: Skidtube RH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-5

Manufactured No

Each

1,832.000

-16



Phenolic Washer



35521

Le

Location

Loc Qty

Loc Code

ST074

1832

35521

1043

44679

220

50354

569

D3672-7

Manufactured No

Each

850.0000

16



Phenolic Washer



6/13/11

Location

Loc Qty

Loc Code

ST074

850

53237

244

64175

606

64175

Monday, June 27, 2011 11:16:36 AM

Shop Packet Print

Page 3

DART Aerospace Ltd

CUSTOMER RETURN

#RA: 111217
Date: MAY 2011Initiator: M. BELLAVANCE
Company: UNITED ROTORCRAFT
Contact: JOHN BRISHAM
Phone No.: 1 840 627 0626Invoice #: 10104624
SO#: 50104660Attach Copy of DHS Return Authorization #: 00464

SQ#: _____ NCR#: _____ CSR#: _____ PAR#: _____

Reason for Return:

SEE ATTACHED

Receiving:

Date Received: 11/6/13 Freight Company: DAY ROSS Prepaid Collect

Qty	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
<u>1</u>	<u>D206-642-513</u>	<u>B42292</u>	<u>SHITUBE</u>		
	<u>514</u>	<u>B42293</u>			

Condition of Packaging: BRUTE DAMAGE Photograph Required: yes noPaperwork Attached: P/S _____ Invoice X penals ARC _____ Docs _____ Other _____

QC:

Quarantine Location: QC Quarantine Condition of Part: Sealed / Accepted / Damaged / ScrapInspectors Initial: S Date: 11/6/13 Photograph Required: yes no

Qty	Part #	CHG #	Batch #	QC Comments	QC Approval		Scrap
					Initial	W/O#	
	<u>D206-642-513</u>	<u>002</u>	<u>42292</u>	<u>see Attached instruction sheet</u>	<u>A</u>	<u>10714</u>	
	<u>D206-642-514</u>	<u>002</u>	<u>42293</u>	<u>see Attached instruction sheet</u>	<u>L</u>	<u>10715</u>	

QA Coordinator:

Advise GM as to Findings: Initial: A Date: 11/06/13

Comments:

Issue Credit: yes noGM Approval: [Signature]Date: 11/06/13Invoice Amount: _____
Less Replacement: _____
Restock Fee: _____
Freight: \$ _____
Net Credit: 15,625.88
DHS Customer

QA: Enter into Q-Pulse with Reason for Return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

RA 111217 D206-642-513 B42292

Instructions to put skid tube back in to stock

- Remove Aft cap and clean out all LPS on the inside and outside of the tube and reinstall aft cap as per QSI 005
- Remove and scrap original rubber gaskets and install new ones

To Bring Skid tube to CHG003 this is needed

- Remove D3672-5 B35521 QTY 16 from kit and put back into stock
- Remove QTY 25 AN3C36A M109771 from kit and put back into stock
- Add QTY 16 D3672-7 B/M# _____ to kit
- Add AN3C37A M# _____ QTY 34 to kit
- Needs new **BATCH #** to be put back into stock under
- Needs new paper work

RA 111217 D206-642-514 B42293

Instructions to put skid tube back in to stock

- Remove Aft cap and clean out all LPS on the inside and outside of the tube and reinstall aft cap as per QSI 005
- Remove and scrap original rubber gaskets and install new ones

To Bring Skid tube to CHG003 this is needed

- Remove D3672-5 B35521 QTY 16 from kit and put back into stock
- Remove QTY 25 AN3C36A M109771 from kit and put back into stock
- Add QTY 16 D3672-7 B/M# _____ to kit
- Add AN3C37A M# _____ QTY 34 to kit
- Needs new **BATCH #** to be put back into stock under
- Needs new paper work



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12 **[Signature]**
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

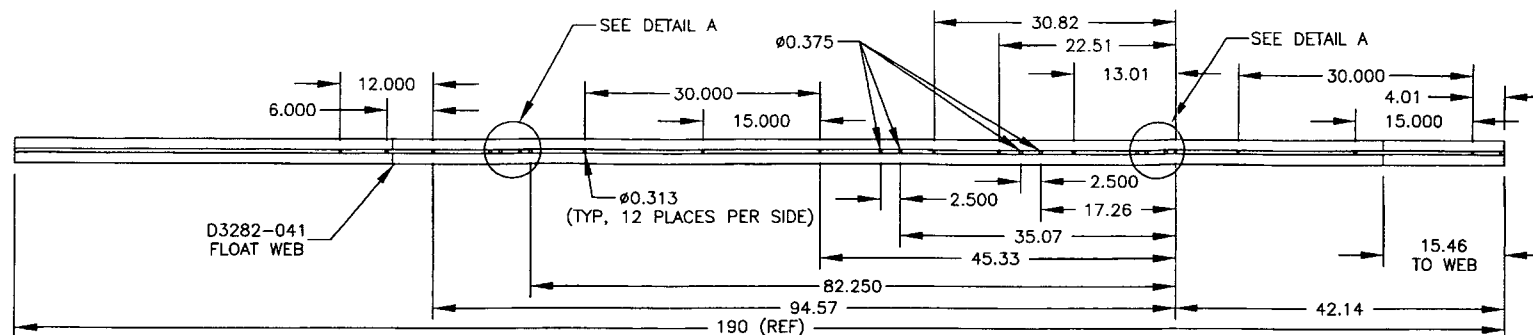
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

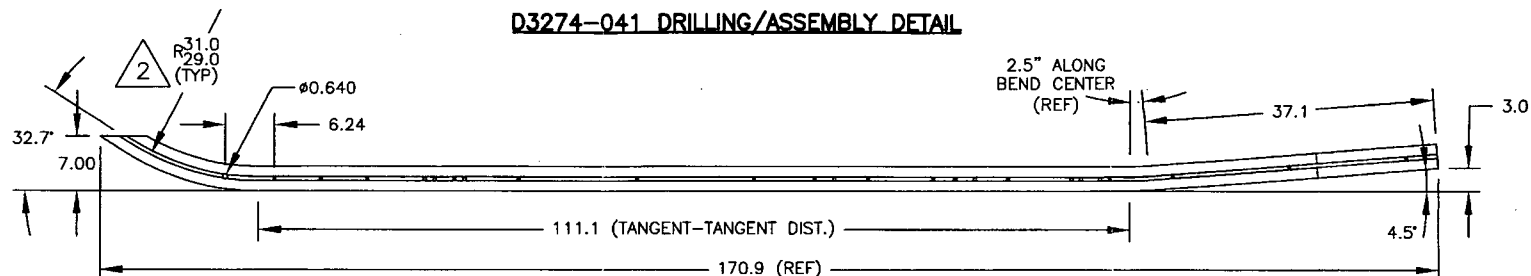
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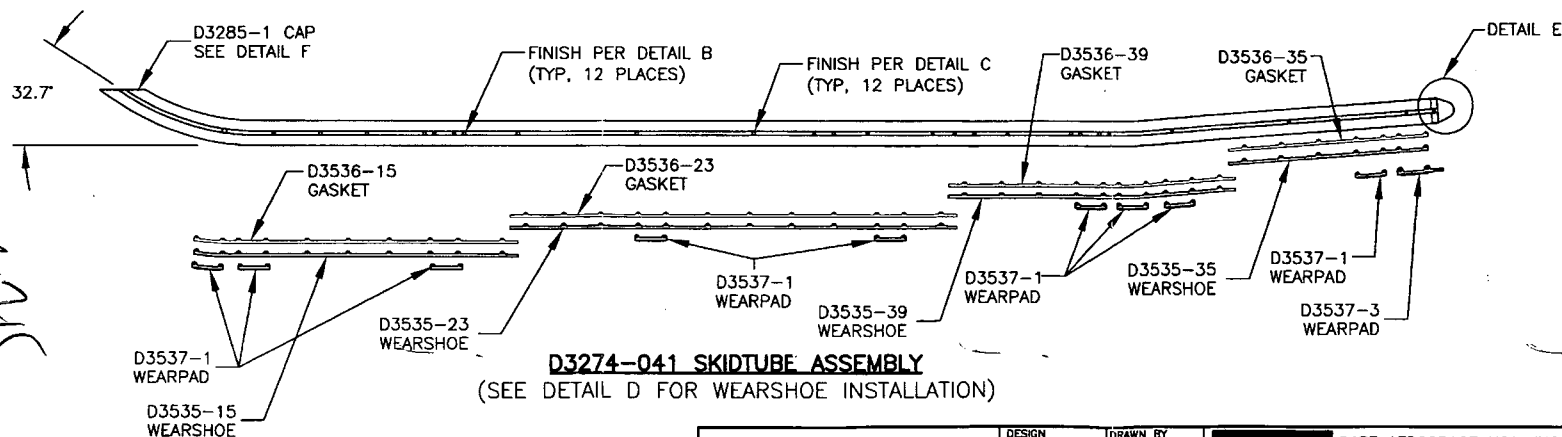
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

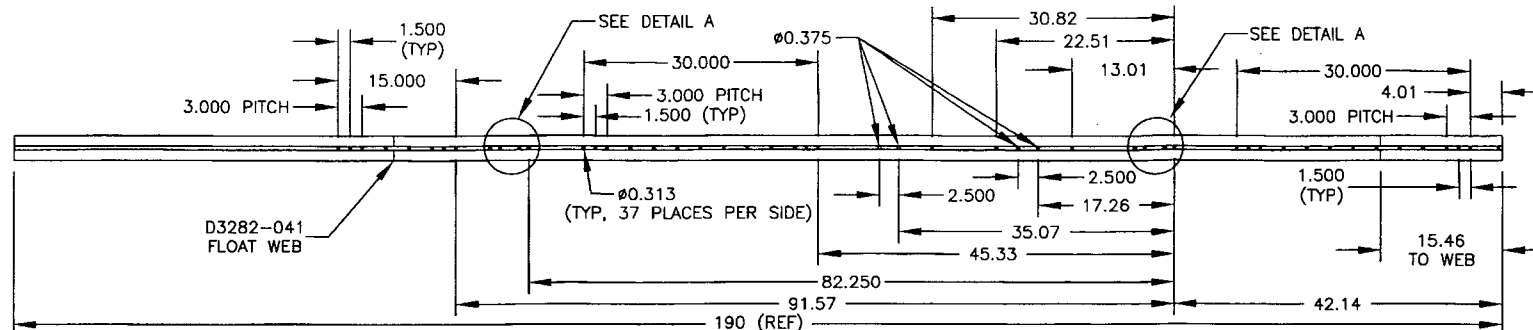
07.02.12

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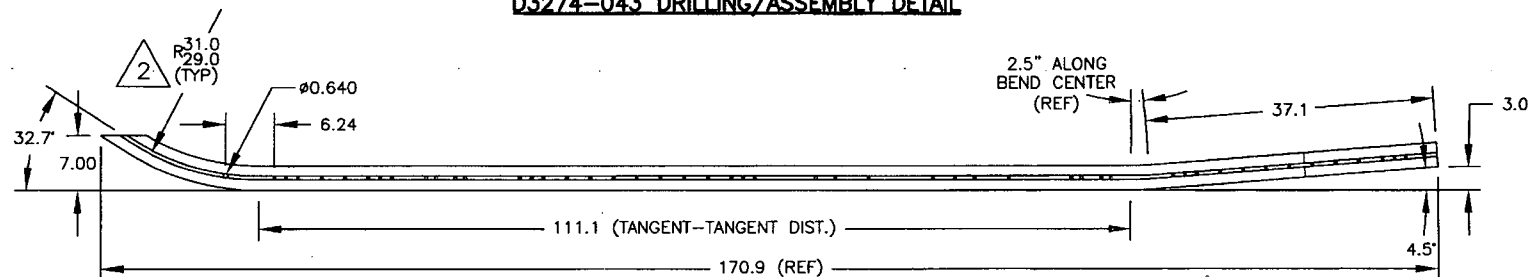
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT KADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

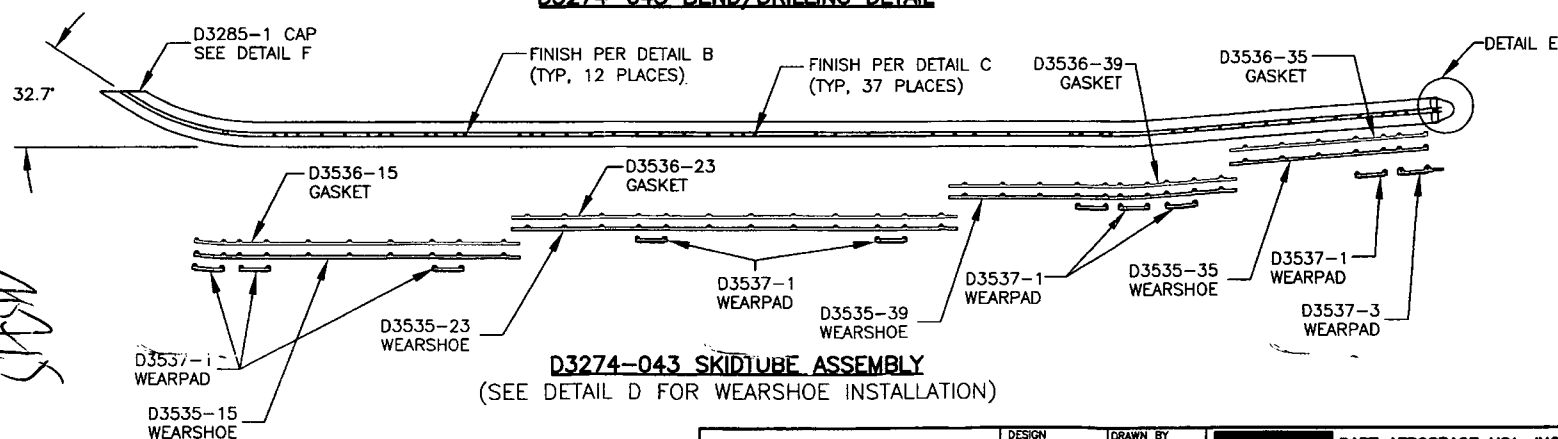
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

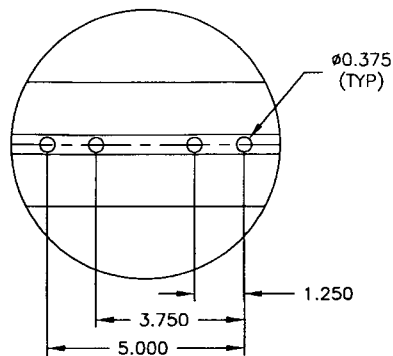
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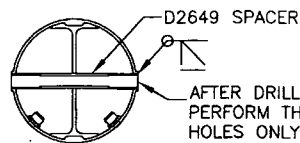
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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. D
CHECKED H	APPROVED H		SHEET 3 OF 4
DATE 06.12.19	DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	SCALE 1:15

DETAIL A: DRILL DETAIL

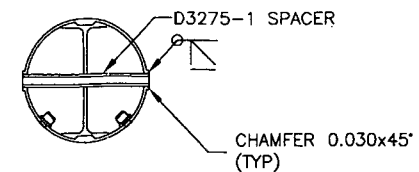


DETAIL B FOR 0.375 HOLES ONLY

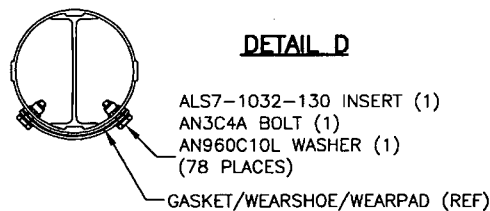


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

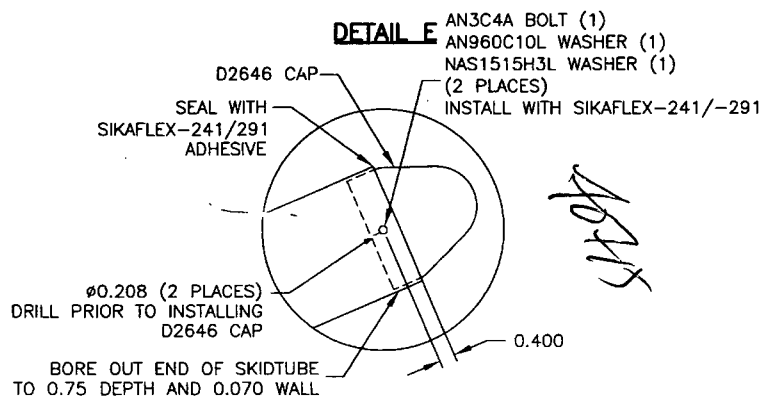
DETAIL C FOR 0.313 HOLES ONLY



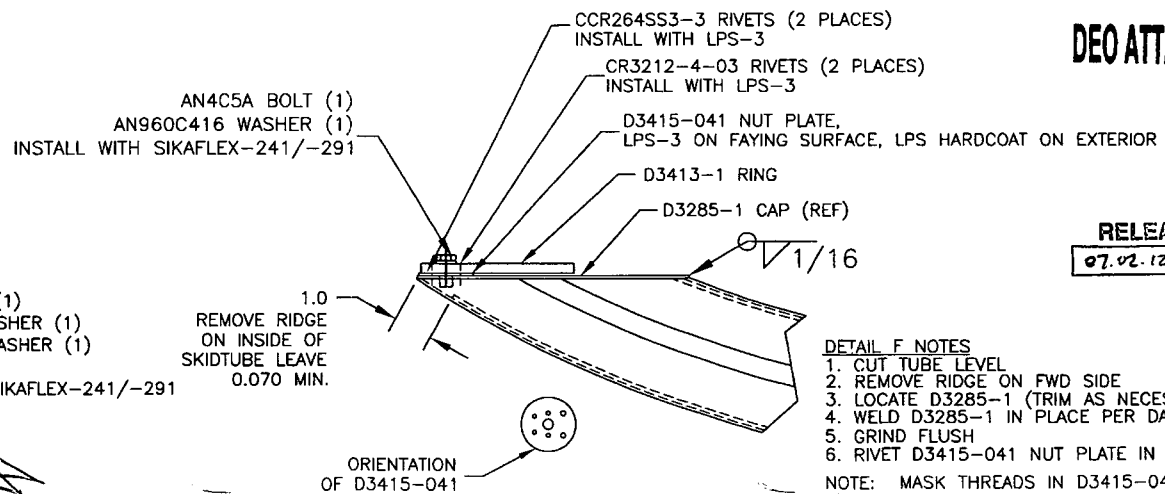
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		REV. D SHEET 4 OF 4 SCALE 1:3

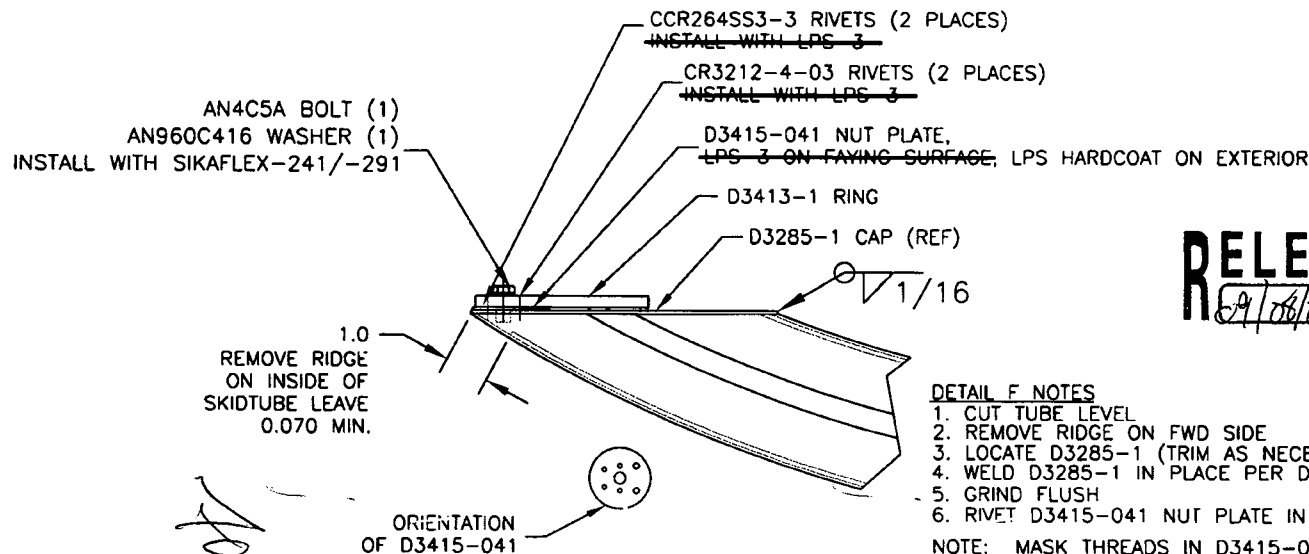
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>1</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MAP</i>	DE APPR. <i>11</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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